

Date: Monday, 04/05/2009 1:44:45 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: REAR OVERHEAD L/H
Job Number	: 47670A		
Estimate Number	: 13589		
P.O. Number	:	Part Number	: D38231 GY
This Issue	: 04/05/2009 S.O. No. :	Drawing Number	: D3823-1
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : THERMOFORMING	Drawing Revision	: B
Previous Run	: 47312A	Material	: MKYD6185S080P362015
Written By	:	Due Date	: 11/05/2009 Qty: 1 Um: Each
Checked & Approved By	: <u>JL009.05.01</u>		
Comment	: Est. A New Issue 08/09/17 DL Rev B Dwg. Update 09/02/09 DL verified by:DD		



Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MKYD6185S080P352068	6185 Kydex .080 steel grey
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MP 09/05/29



Comment: Qty.: 11.3747 sf(s)/Unit Total: 11.3747 sf(s)
 6185 Kydex .080"

M111807

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Machine set up

BB 09/05/21

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

BB 09/05/21 (x2)

4.0	THERMOFORMING	THERMOFORMING MACHINE
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Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3823-1 and folio FTA 030 using tool DT 9112

Dwg. Rev. B
 Folio Rev. B

BB 09/05/21 (x2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: . ' Monday, 04/05/2009 1:44:45 PM
User: * Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REAR OVERHEAD L/H

Job Number: 47670A

Part Number: D38231

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 09/05/21 (X2)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

09-05-25 (2)

MF 09/05/21

(X2)

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

MF 09/05/21

(X2)

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

MF 09/05/21

(X2)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-05-25 (2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPP47670

POSITIVE RECALL

EFFECTIVE 09-05-20

AUTH 11

EASED 11

DATE 9/15/25

MF 09/05/26 (X2)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-05-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 47670A
Description:	Part Number: 03823-1
Inspection Dwg: 03823-1 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____" N/A.				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 09/05/22

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.44"	MIN	0.55	✓			
1.25"	MIN	1.80	✓			
0.50"	MIN	0.54	✓			
0.045"	MIN	0.065	✓			
0.055"	MIN	0.064	✓			

Measured by: BB

Date: 09.05.22

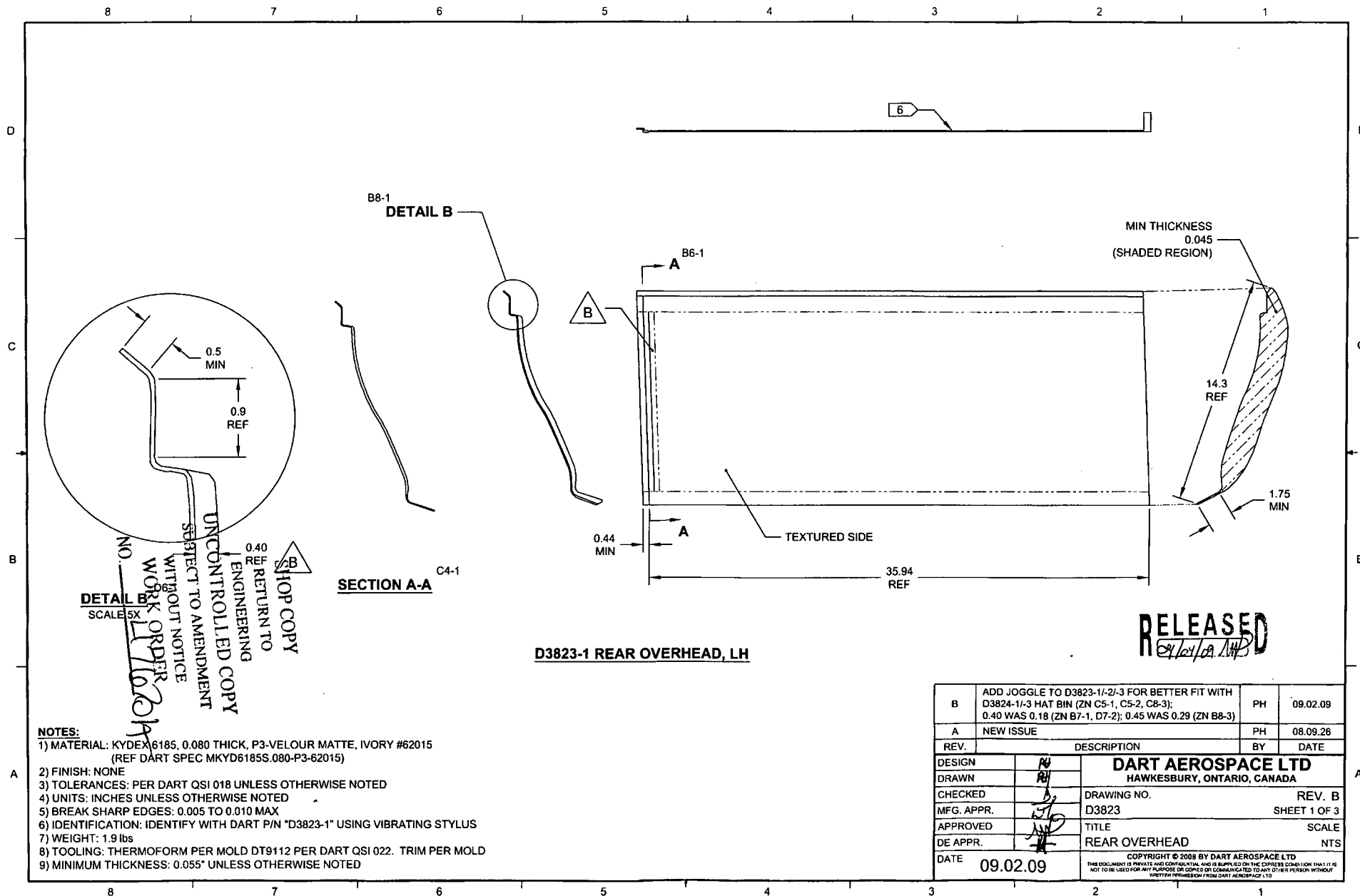
Audited by: [Signature]

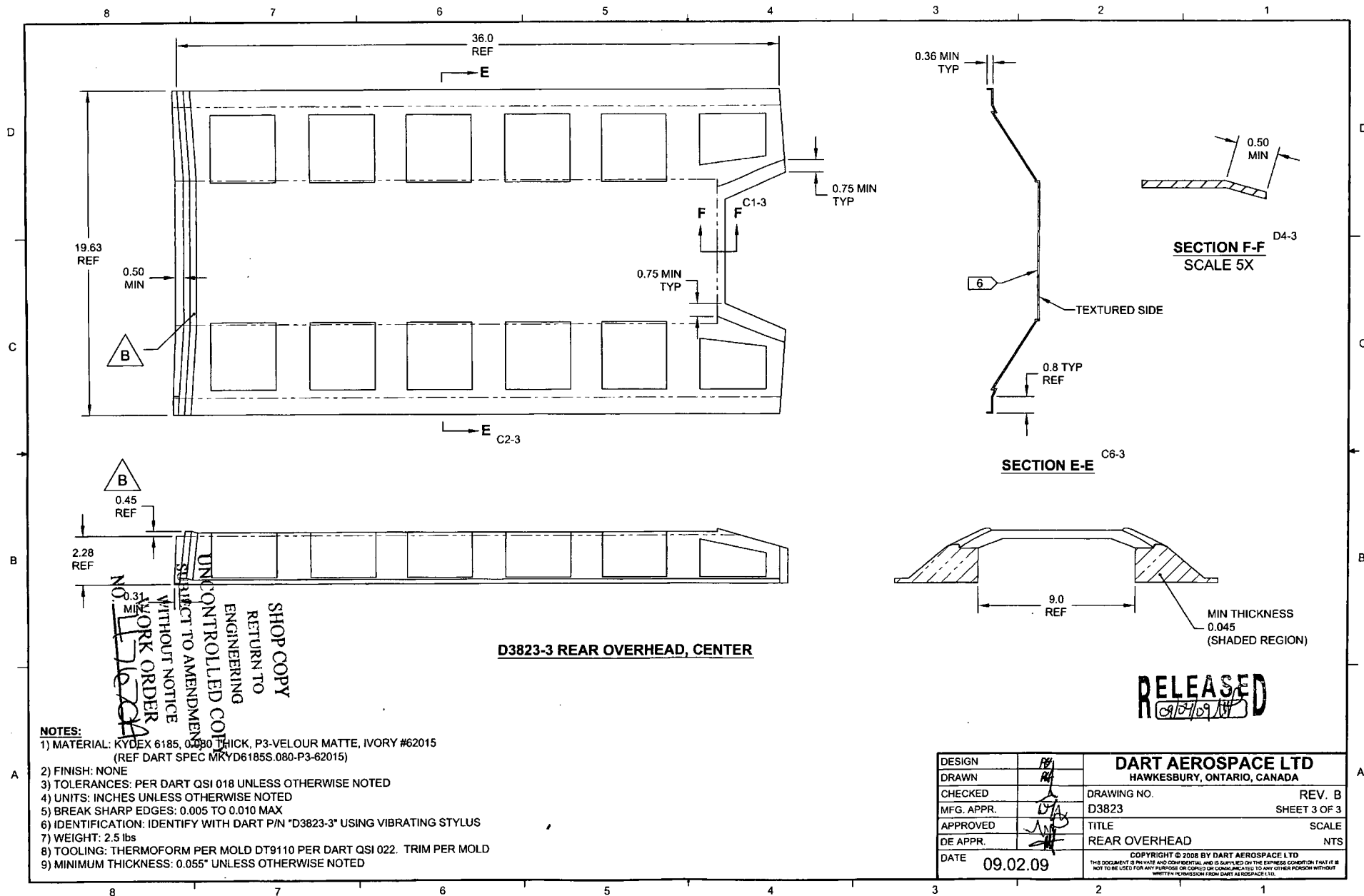
Date: 09.05.25

Prototype Approval: _____

Date: _____

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	





DESIGN	FR	DART AEROSPACE LTD	
DRAWN	RA	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	LA	D3823	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		REAR OVERHEAD	NTS
DATE	09.02.09	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

